

Ship Tues 7/06 Split

Order ID 70366

y, June 03, 2011 12:42:39 PM



Page 1

Item ID: D4103-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step / Handle

Start Date: 6/3/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4103

A

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

cut 10/06/06

2 X

Jeaspa Bandsaw

6.200" long

110

0.00



HAAS I

Memo

0.00

cut 11/06/07

2 X

HAAS CNC vertical machine #1

Mill as per dwg and Folio FA937

DEBURR

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

cut 11/06/07

2 X

Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

SL 11/06/07

2

2 0 BR 11-6-7.

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

2 0 SL 11/06/07

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Work Order ID 70366

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Page 3

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Accept



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Item Name: Step / Handle

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Cust Item ID:

Required Date: 6/7/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/6/7 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/7 JG
C21106/07

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

Friday, June 03, 2011 12:42:35 PM

Page 1

Work Order ID: 70366

Parent Item: D4103-1

Parent Item Name: Step / Handle



Start Date: 6/3/2011

Required Date: 6/7/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV: A NEW ISSUE 10-07-01 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	4.7284	0.52	5.473684			



6061-T6 Bar 2.00 x 3.50



Location

MAT009

→ 112764

Loc Qty

4.7284

4.7284

Loc Code

4.00 and 11/06/06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 40366
Description: Step/Handle		Part Number: D4103-1
Inspection Dwg: D4103 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.93	+/-0.030	2.930	—		Vern M1-2	
0.37	+/-0.030	.370	—		"	
0.83	+/-0.030	.829	—		"	
Ø0.560	+/-0.010	Ø.564	—		"	
0.06 X 45°	+/-0.030 X +/-0.5°	Ø.06 X 45°	—		"	
0.26	+/-0.030	.254	—		"	
0.33	+/-0.030	.337	—		"	
R0.06	+/-0.030	R.060	—		R-6	
1.78	+/-0.030	1.780	—		Vern M1-2	
0.45	+/-0.030	.444	—		"	
0.33	+/-0.030	.315	—		"	
0.75	+0.000/-0.030	.747	—		"	
1.66	+/-0.030	1.648	—		"	
0.80	+/-0.030	.770	—		"	
1.07	+/-0.030	1.077	—		"	
3.85	+/-0.030	3.848	—		"	
0.03 X 45°	+/-0.030 X +/-0.5°	Ø.03 X 45°	—		"	
0.31	+/-0.030	.310	—		"	
0.28	+/-0.030	.280	—		"	
0.030 Deep	+/-0.030	.030	—		"	
6.00	+/-0.030	5.999	—		"	
R0.27	+/-0.030	R.270	—		"	
0.56	+/-0.030	.555	—		"	
1.74	+/-0.030	1.747	—		"	
2.50	+/-0.030	2.500	—		"	
Ø0.438	+0.006/-0.001	Ø.440	—		"	
Ø0.266	+0.006/-0.001	Ø.268	—		"	
0.96	+/-0.030	.960	—		"	
0.26	+/-0.030	.253	—		"	
0.25	+/-0.030	.245	—		"	
2.25	+/-0.030	2.249	—		"	
1.00	+/-0.030	1.001	—		"	
0.20	+/-0.030	.203	—		"	
0.98	+/-0.030	.980	—		"	
0.32	+/-0.030	.315	—		"	
1.25	+/-0.030	1.248	—		"	
R0.19	+/-0.030	R.190	—		"	

Measured by: CMK	Audited by: JI	Preliminary Approval:
Date: 11/06/07	Date: 11/06/07	Date:

Rev	Date	Change	Revised by	Approved
A	10.10.07	New Issue	KJ	

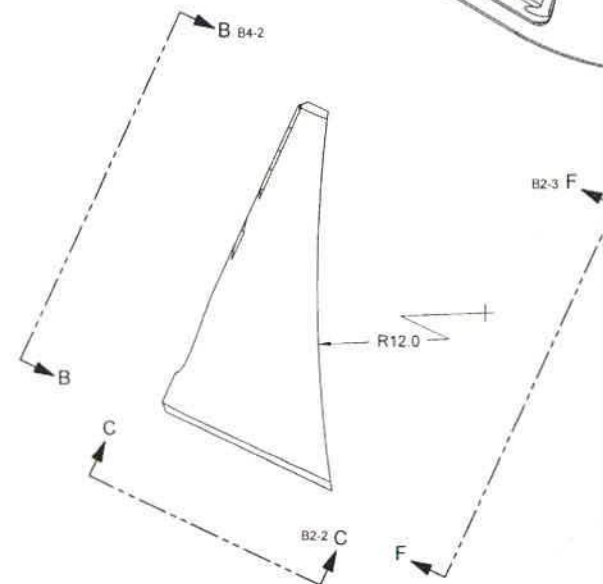
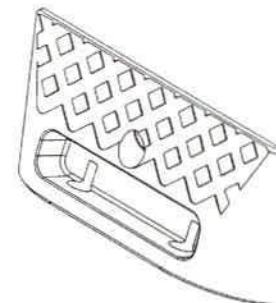
W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries



P/HANDLE

RELEASED
2010-08-23
WAB

NOTES

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4013-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.81 lbs
- 8) MACHINE 0.28 x 0.31 GRIP 0.030 DEEP AT 45° PATTERN 0.25 APART

A	NEW ISSUE		RF	10.05.17
REV		DESCRIPTION	BY	DATE
DESIGN	RF	DART SPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO D4103 TITLE STEP/HANDLE	REV. A	
DRAWN	RF		SHEET 1 OF 1	
CHECKED	RF		SCALE	
MFG. APPR.	RF		NTS	
APPROVED	RF			
DE APPR.	RF			
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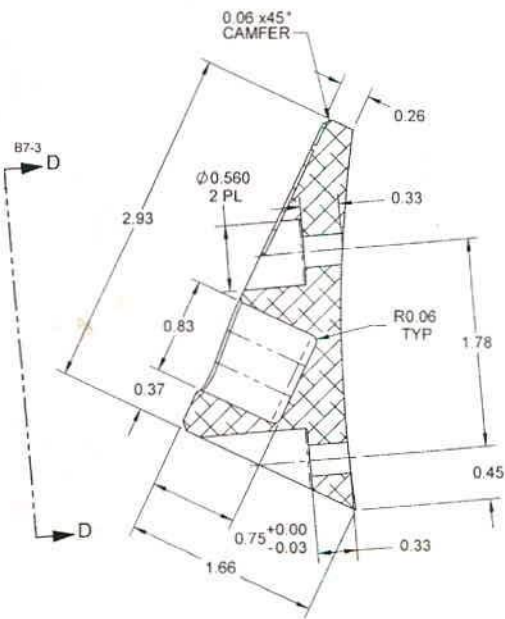
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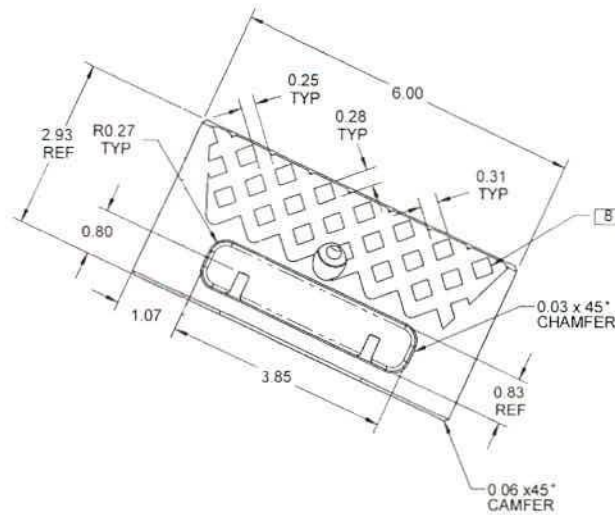
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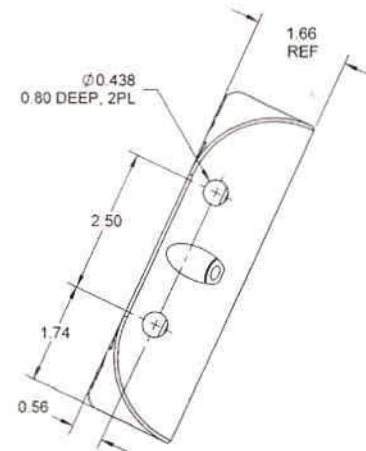
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SECTION A-A D6-1



VIEW B-B D3-1
SCALE 0.5X



VIEW C-C B2-1
SCALE 0.5X

RELEASED
2010-08-23

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4103	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP/HANDLE	NTS
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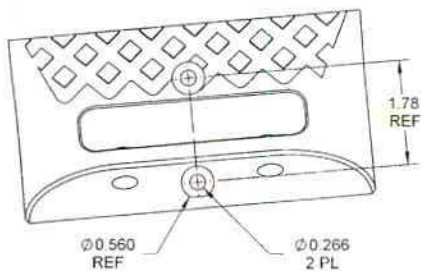
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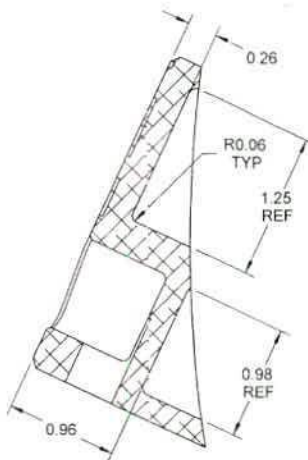
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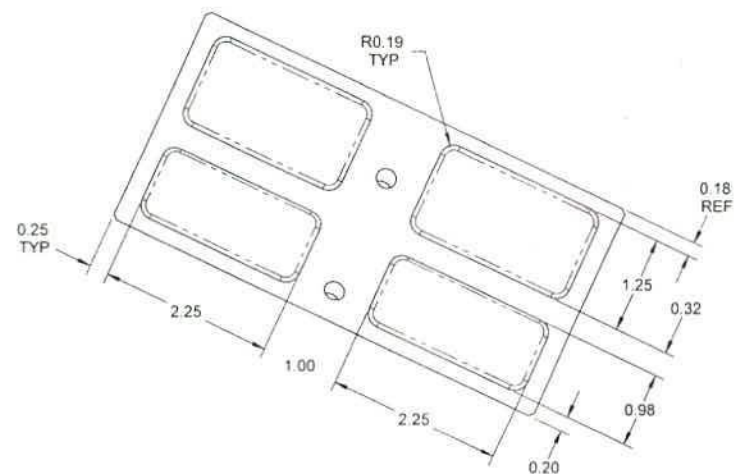
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VIEW D-D C8-2
SCALE 0.5X



VIEW E-E D7-1



VIEW F-F C1-1

20366

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2010-08-23
ND

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DRAWN	RF		
CHECKED	RF	DRAWING NO. D4103	REV. A
MFG. APPR.	RF	SHEET 3 OF 3	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	STEP/HANDLE	NTS
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